



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel: (613) 632-5200

RB KIT 407M-19
Job Sheet 174658



DAS
13
9-88

Part No: RB KIT 407M-19

Job Qty: 6 ea

Part Name: Gauge Pin .1440"

MAR 27 2018

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/18

Job Tracking No:

Due Date: 3/23/18

Created By: Chantal Lavoie

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Purchasing	6 pcs	3/22/18	3/22/18	0.00	0.00	Purchasing		MIC
100	Receive Pcs	6 pcs	3/22/18	3/22/18	0.00	0.00	Packaging2		MIC DAS
105	QC	6 pcs	3/22/18	3/22/18	0.00	0.00	QC6		38
110	Small	6 pcs	3/23/18	3/23/18	0.00	1.20	Small Fab-6		MIC DAS 38
120	QC	6 pcs	3/23/18	3/23/18	0.00	0.00	QC5		38
130	Packaging	6 pcs	3/23/18	3/23/18	0.00	0.00	Packaging3		9-88
140	QC21-SA	6 Ea	3/23/18	3/23/18	0.00	0.00	QC21		DAS 21 38

Part Op 95 - Select .1440" diameter pin under part number 21135A54
Descriptions: 110 - Cut pin make multiple -19's -Deburr -Bag and Identify.

MAR 29 2018

Part / Item
21135A54

Component Name
Plug Gauge

Job BOM

Quantity
6 Ea (1 ea)

Operation
95-Purchasing

Container

Operation
95-Purchasing

Component Part
21135A54

Job Allocations

Required
6

Inventory
7

Allocated
0

Part Specifications

Specifications could not be found.

Plex 3/20/18 12:02 PM dart.lavoie.chantal



Container No: S055565

Part: RB KIT 407M-19

Job No: 174658

Serial No/Batch: S055565

Revision:

Inspector:

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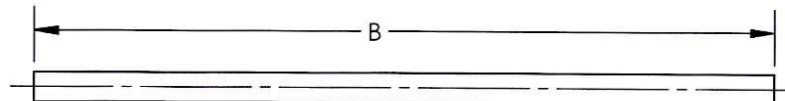
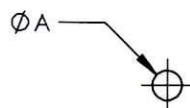
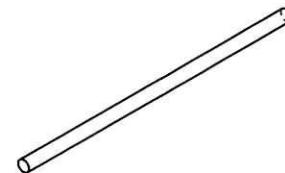
Date: 03/27/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0085	-01 THRU -31 ADDED GAUGE PIN DIMENSIONS TABLE.	4/6/2017	RJC	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

174658 NO. ~~171511~~ MLS
~~173587~~ 18-02-01



GAUGE PIN DIMENSIONS

PART NUMBER	ØA	B
-01	(Ø.0240)	1"
-03	(Ø.0400)	1"
-05	(Ø.0540)	1"
-07	(Ø.0600)	1"
-09	(Ø.0800)	1"
-11	(Ø.0960)	1"
-13	(Ø.1080)	1"
-15	(Ø.1200)	1"
-17	(Ø.1440)	1"
-19	(Ø.1440)	1 1/4"
-21	(Ø.1600)	1"
-23	(Ø.1600)	1 1/4"
-25	(Ø.1728)	1"
-27	(Ø.1728)	1 1/4"
-29	(Ø.1800)	1"
-31	(Ø.1920)	1"

-01 THRU -31
GAUGE PIN

DART AEROSPACE	
TITLE SPLINE MEASURING KIT ASSY	
DWG NO. RB KIT 407M-01 THRU -31	REV 2
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 407
SCALE 4:1	DATE 12/7/2016
SHEET 2 OF 5	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					